

Date: Monday, 11/08/2008 2:45:37 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
 Job Number : 41129
 Estimate Number : 10834
 P.O. Number :
 This Issue : 11/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D29332
 First Issue : // Type : MACHINED PARTS Drawing Number : D2933 REV C
 Previous Run : 39889 Project Number : N/A
 Written By : Drawing Revision : C
 Checked & Approved By : JLD 08.8.11 Material :
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC Due Date : 6/09/2008 Qty: 10 Um: Each
 Est Rev: C As per Rev C 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: B34872

ml 08/08/30

(10)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 5-Deburr

ml 08/08/30

(10)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

ml 08/08/30

(10)

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

ml 08/08/30

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 2:45:37 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 41129

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



(10)

Comment: SECOND CHECK

DIP 08/08/31

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(10)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/09/02

7.0

POWDER COATING

POWDER COATING



M108523



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:20

OVEN TEMPERATURE:

320

FINISH TIME:

10:30

M-F 08/09/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

Comment: INSPECT POWDER COAT

FL 08/09/02

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 428A

SS 08/09/02

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41129
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.124	.125	.123		
B	0.100	0.140		.124	.124	.125	.125		
C	0.100	0.140		.117	.118	.122	.122		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.516	.511	.511		
I	1.572	1.582		1.576	1.577	1.577	1.575		
J	2.495	2.505		2.499	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.231		
N	0.100	0.140		.122	.122	.122	.123		
O	0.540	0.560		.543	.548	.547	.548		
P	0.490	0.510		.503	.504	.502	.502		
Q	3.715	3.725		3.717	3.720	3.720	3.719		
R	2.470	2.510		2.491	2.491	2.491	2.490		
S	0.240	0.270		.251	.249	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.628	1.627	1.627	1.629		
V	1.362	1.372		1.367	1.366	1.366	1.367		
W	0.316	0.321		.320	.320	.320	.326		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.572	1.572	1.571	1.572		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>amf</i>
Date: 08/08/30

Audited by: <i>JP</i>
Date: 08/08/31

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JA</i>	<i>JP</i>

DART AEROSPACE LTD		Work Order: 41129
Description: 206 Saddle, Inboard, Right side		Part Number: D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.123	.125	.125	.126		
B	0.100	0.140		.123	.125	.126	.126		
C	0.100	0.140		.122	.122	.122	.122		
D	0.210	0.230		.221	.221	.222	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.511	.510	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.236	.237	.236	.237		
N	0.100	0.140		.122	.122	.122	.122		
O	0.540	0.560		.546	.547	.547	.549		
P	0.490	0.510		.502	.501	.501	.501		
Q	3.715	3.725		3.720	3.718	3.719	3.719		
R	2.470	2.510		2.490	2.490	2.496	2.496		
S	0.240	0.270		.249	.249	.249	.249		
T	0.100	0.180		.146	.146	.146	.146		
U	1.625	1.635		1.627	1.631	1.630	1.630		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.572	1.572	1.572	1.572		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	08/08/31

Audited by:	<i>[Signature]</i>
Date:	08/08/31

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 41129
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

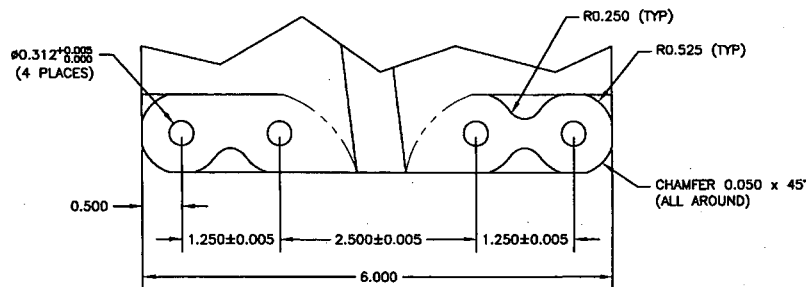
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.125				
B	0.100	0.140		.125	.125				
C	0.100	0.140		.119	.120				
D	0.210	0.230		.221	.222				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.512	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.259	.259				
L	0.312	0.317		.315	.314				
M	0.235	0.240		.238	.236				
N	0.100	0.140		.122	.124				
O	0.540	0.560		.550	.548				
P	0.490	0.510		.504	.504				
Q	3.715	3.725		3.717	3.718				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		.249	.251				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.628	1.628				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.320	.320				
X	1.125	1.145		1.135	1.135				
Y	1.565	1.585	DT8695 A/B	1.572	1.572				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>ML</i>
Date: 08/08/31

Audited by: <i>DJP</i>
Date: 08/08/31

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

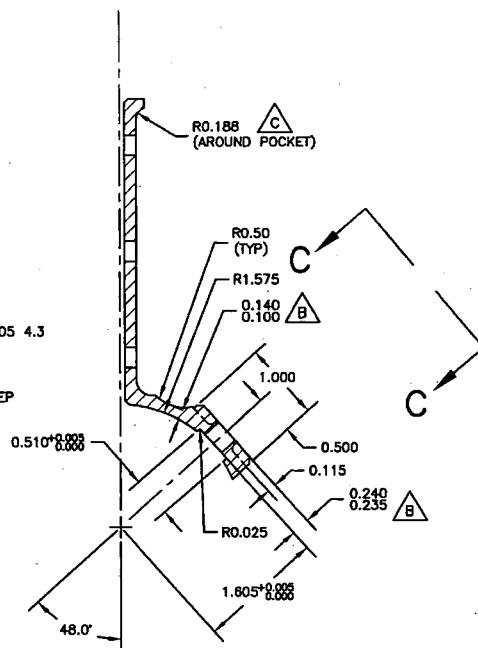


VIEW C-C

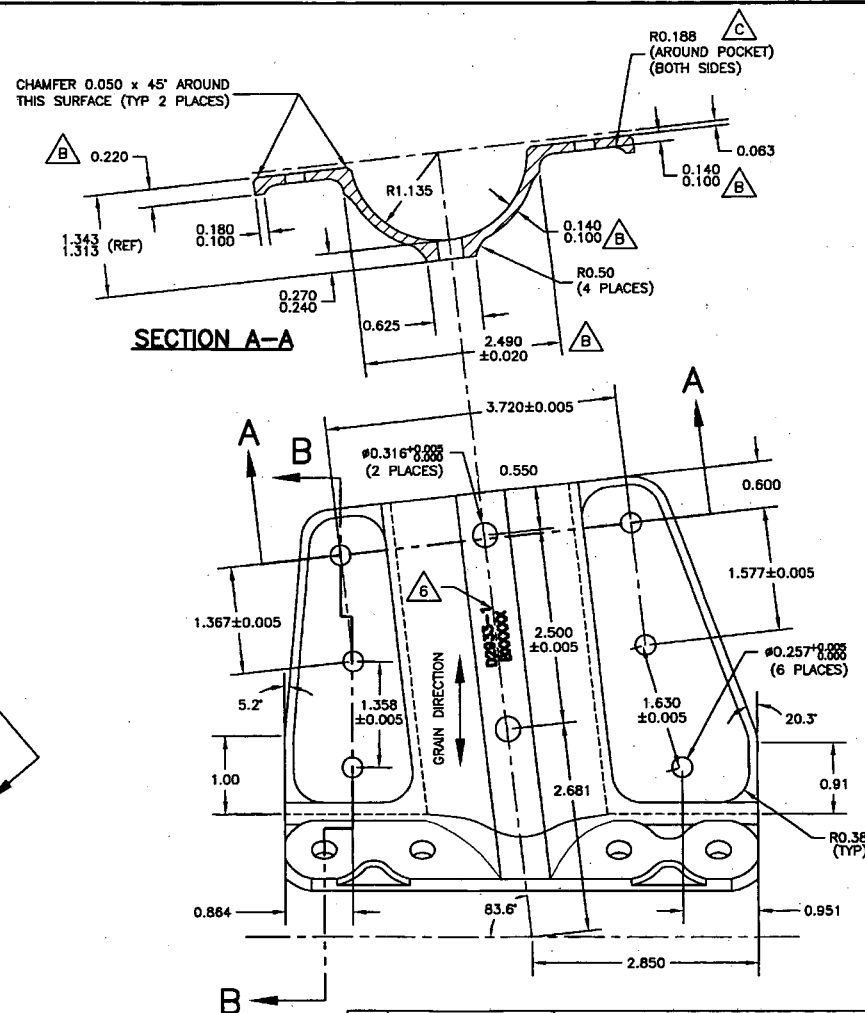
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE INSIDE
DRAWING NO. D2933		REV. C
DART DART AEROSPACE USA, INC. BELLEVUE, WA		SHEET 1 OF 1
		SCALE 2:3

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07-01-12

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